

Date: Wednesday, 03/06/2009 8:48:30 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CHAIN LUG
Job Number	: 48343		
Estimate Number	: 13992		
P.O. Number	:	Part Number	: D39545
This Issue	: 03/06/2009 S.O. No. :	Drawing Number	: D3954 REVA
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	:	Material	:
Written By	:	Due Date	: 03/06/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>mf 09-06-03</u>		
Comment	: Est Rev:A 09-06-02 new issue EC verified by:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304B1500X1500	m1010B1.00x2.50 304 bar 1.50"x1.50
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m1010B2500XD1000



Comment: Qty.: 0.5250 f(s)/Unit Total: 0.5250 f(s)

~~304/316 Bar 1.50"x1.50"~~

Batch: 7110740

mf 09/06/03

①

2.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

mill to size

mf 09/06/03

①

3.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

B9-6-3

①

2-Deburr if necessary

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B9-6-3



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

mf 09-06-03

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: CHAIN LUG

Job Number: 48343

Part Number: D39545

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify as per dwg and Stock

Location: _____

Dan St.

MF 09-06-09

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/04 JF

Job Completion



MF 09-06-04

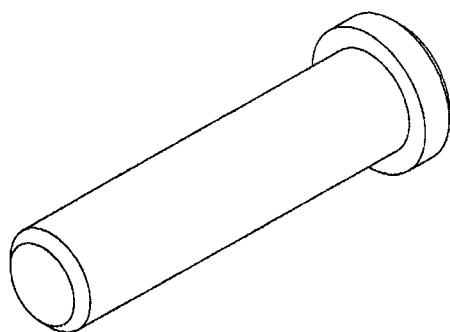
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

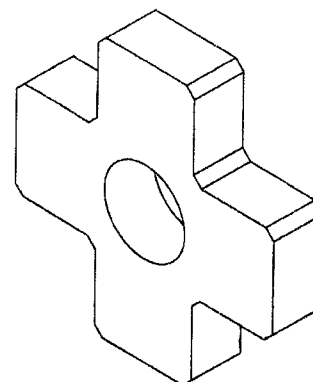
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

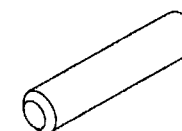
NOTE: Date & initial all entries



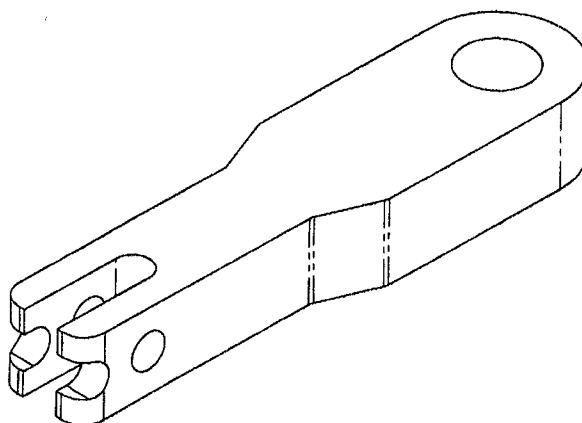
D3954-1 GWT PIN



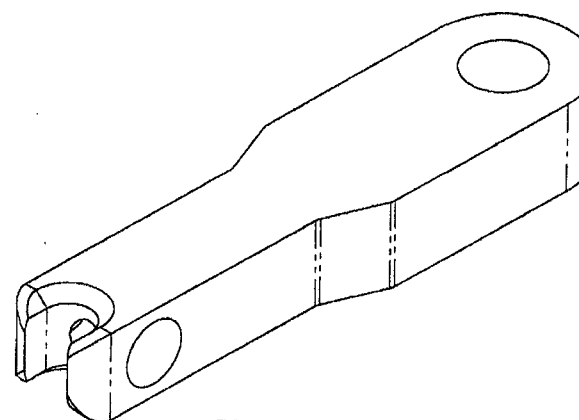
D3954-3 GWT KNOB



D3954-9 GWT CHAIN PIN



D3954-5 CHAIN LUG

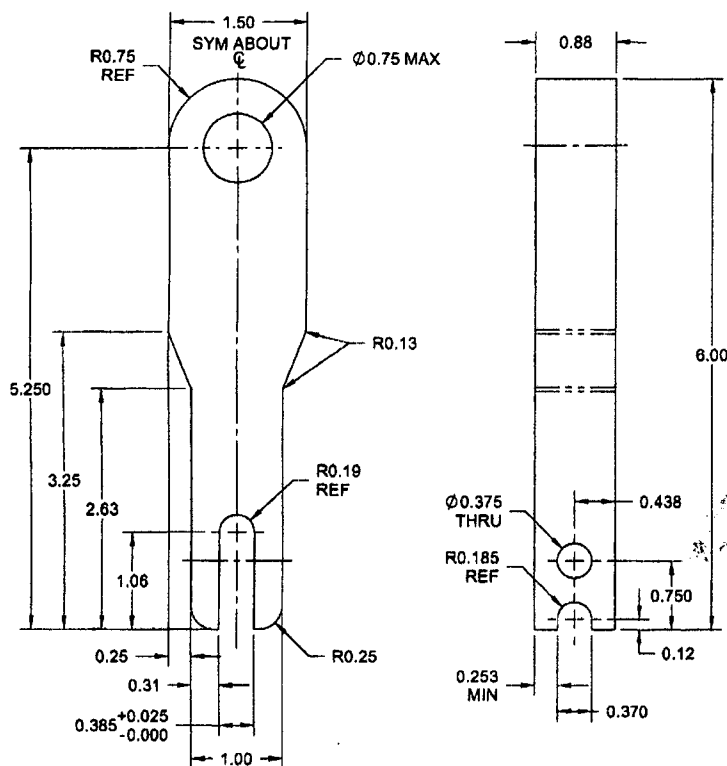


D3954-7 RATCHET LUG

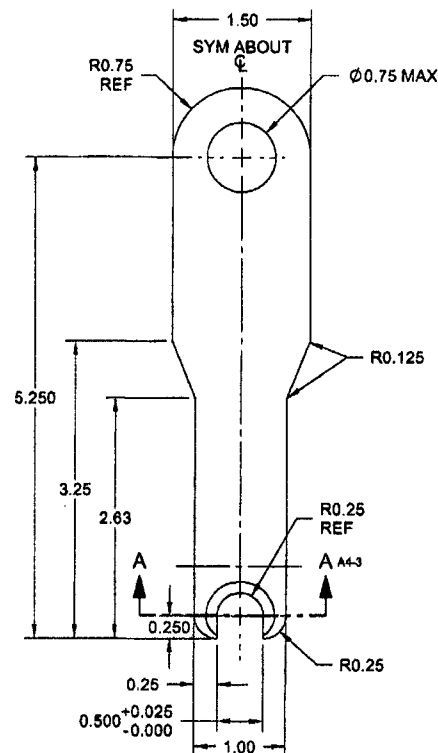
RELEASED
CH/16/02-100

Mo 48343

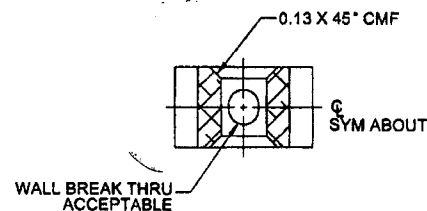
A		NEW ISSUE		AJS		09.05.26	
REV.		DESCRIPTION		BY		DATE	
DESIGN	AJS/DSTOW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				REV. A	
DRAWN	AJS					SHEET 1 OF 3	
CHECKED	<i>[Signature]</i>	DRAWING NO.					
MFG. APPR.	<i>[Signature]</i>	D3954					
APPROVED	<i>[Signature]</i>	TITLE				SCALE	
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT				NTS	
DATE		09.05.26		<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>			



D3954-5 CHAIN LUG



D3954-7 RATCHET LUG



D3954-9 GWT CHAIN PIN

NOTES:

1) MATERIAL -5/-7: AISI 303/304 STAINLESS STEEL BAR
REF DART SPEC M303/304B

-9: AISI 303/304 STAINLESS STEEL ROUND BAR
REF DART SPEC M303/304R

2) FINISH -7 ONLY: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED


5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -5/-7: 1.56 lbs EACH

-9: 0.05 lbs

SECTION A-A C3-3

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3954	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
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RELEASED
09/06/02

460 48343